Work Order ID 105940 - 2

105940

Page 1

Tuesday, August 27, 2013 7:30:15 AM Setup Start Accept *N900040100* D2230-3 Item ID: Revision ID: Stop MOUNTING LUG Item Name: Start Qty: 250,00 Cust Item ID: 8/27/2013 Start Date: Req'd Qty: 250.00 Customer: Required Date: 9/20/2013 Reference: Start Run Date: 13/08/27 Tooling: Date: Process Plan: Approvals: Stop Date: SPC (Y/N): Date: OC: Reject Reject Insp. Tool # Plan Accept Tool ID Set Up/ Operation Sequence ID Qty Number Stamp Qty Code **Run Hours** Description Work Center ID Revision Nbr Draw Nbr D2230 Rev G 0.00 Outsource process - Machining 110 CX 13/08/27 250 HAAS CNC VERTICAL MACHINING #1 *110* 0.00 Outsource5 Memo Issue P/O to Metec : Outsource process - Machining Machine as per dwg C of C is required 0.00 Receive & Inspect for Damage & Mat'l Certs 120 *120* 0.00 Packaging Memo Ensure C of C is attach Packaging CX Bulat 0.00 QC6- Inspect dimensions to drawing 130 *130* Memo OC Quality Control

NCR: Y	es / N	0			WORK ORDER NON-	CON	IFORI	MANCE / UP	PDATE	QA Closed:	Date:	Bat 2
Work Orde					DISPOSITION				AGAINST D	EPARTMENT/	PROCESS	
Part N	o			=	Rework Scrap Use-as-is Work Order Update Rework Skid-tube Machining Small Fab Thermoforming Large Fab Composite				Prod. Eng. Coor. Quality Rec/Store/Packaging Other Supplier			
Root Cause	Dat	e Step	Qty		iption of work order update or Non-conformance		nitial ief Eng		cription	Sign & Date	Verification	QC Inspector
quip/Tooling pperator Material etup Other Process supplier Training Unapproved	c/Data											
					F	AUL	T CATE	GORY		B 55		
Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes	M/Route Hardware ken/Damaged Inspection Incomplete s Instructions Incomplete/Unclear kamination Maintenance ntersink Mislabeled Misread			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
J		e Waves in	Extrusio	n	Drawing			Calibration			But die	The Contract of the Contract o
Turning Sequence				Finish		Out of Sequence						

Outside Dimensions

Wave/Twist in Tube

105940 Page 2 Work Order ID 105940 Tuesday, August 27, 2013 7:30:15 AM *N900040100* Setup Start Accept D2230-3 Item ID: Revision ID: Stop MOUNTING LUG Item Name: *250* Cust Item ID: Start Qty: 250.00 8/27/2013 Start Date: Customer: Req'd Qty: 250.00 *250* Required Date: 9/20/2013 Reference: Start Run Date: Tooling: Date: Process Plan: Stop Approvals: Date: SPC (Y/N): Date: OC: Reject Reject Insp. Tool # Plan Accept Tool ID Set Up/ Operation Sequence ID/ Qty Qty Number Stamp Code Run Hours Description Work Center ID Chemical Conversion Coat per OSI005 4.1 0.00 140 13/11/21 NA *140* Memo HandFinish Hand Finishing 0.00 QC3-Inspect Part Finish CZ 13/11/21 150 *150* 0.00 Memo OC Quality Control White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00 CZ 13/11/21 160 *160* 0.00 Powdercoat Memo START TIME: Powder Coating OVEN TEMPERATURE: m 126125 A.T.G. alodine of pount FINISH TIME:

NCR: Yes / No

NCR No.

Root

Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapprove

Work Order:

Part No.

Date

Qty

Step

WORK ORDER NON-CONFORMANC

Initial

Chief Eng

DISPOSITION

Work Order Update

Description of work order update

or Non-conformance

Rework

Use-as-is

Scrap

	DOA	Date:	
FORMANCE / UPDATE	DQA:QA Closed:	Date:	
AGAINST D	EPARTMENT/	PROCESS	
Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite	The state of the s	Water Jet J. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
itial Action ef Eng Description	Sign & Date	Verification	QC Inspector

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andi	ng (Gear	General					
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		Centre Not Concentric to O/S	BOM/Route		Hardware	2.75	Over/Under tolerance	Temperature/Cure
		Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	Weld
		Crushed/Crimped	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrang Stock Pulled
		Cuffs	Contamination		Maintenance	100	Part Moved	
		Heat Treat	Countersink		Mislabeled	700	Positioned Wrong	
	Deal.	Inspection Strip in Tube	Cut Too Short		Misread	100	Power Loss/Surge	Other
		Ripples in Bend	Drill Holes		Offset			
		Torque Waves in Extrusion	Drawing		Out of Calibration			
	· V	Turning Sequence	Finish		Out of Sequence		STORES AND STORES	Silvin Jan 199
		Wave/Twist in Tube	Folio		Outside Dimensions	-	排走整线 — 1 — 1 — 1 — 1	

105940

Page 3

Tuesday, August 27, 2013 7:30:15 AM

Item ID:

D2230-3

Accept

N900040100

Setup Start

Revision ID:

Item Name:

MOUNTING LUG

Start Date:

Required Date: 9/20/2013

8/27/2013

Start Qty: 250.00 Reg'd Qty: 250.00 *250* *250* Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

OC:

Date:

Date:

Tooling: SPC (Y/N): Date:

Date:

Run

Start

Stop

Reject

Qty

Stop

Sequence ID/ Work Center ID

170

OC

Operation Description

QCB-Inspect Part Finish

Memo

Set Up/ DAS Run Hours 0.00 9-89

Tool ID

Tool # Plan Code

Accept Qty

Reject Number Stamp

Insp.

Quality Control

180

170

120 Packaging

Packaging

Identify as per dwg & Stock Location 57969

Memo

0.00

0.00

DAS 32 9-89

190

190 QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

113-11-22

NCR: Y	es / No	Service of the servic			WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:								
Nork Ordo	in a				DISPOSITION		AGAIN	NST DEPARTM	ENT/PROCESS				
Work Orde Part N NCR N	0				Rework Scrap Use-as-is Work Order Update	The	Skid-tube Crosstu Machining Small I moforming Finish Large Fab Compos	Fab Rec	Water Jet Prod. Eng. Coor. /Store/Packaging Supplier	Engineering Quality Other			
Root					ption of work order update	Initial	Action	Sign					
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Description	Dat	e Verification	QC Inspector			
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4	Centre	Not Conce	ntric to	o/s	BOM/Route	Hardy	vare	Over/U	nder tolerance	Temperature/Cure			
100	Cracks				Broken/Damaged	Inspe	ction Incomplete	Part Inc	prrect	Wed			
	Crushed	/Crimped			Burrs	Instru	ctions Incomplete/Unclear	Part Lo	st/Missing	Wrang Stock Pulled			
	Cuffs				Contamination	Main	tenance	Part Mo	oved				
D4	Heat Tr	eat			Countersink	Misla	beled	Position	ned Wrong				
F. 1	Inspect	on Strip in	Tube		Cut Too Short	Misre	ad	Power	loss/Surge	Other			
2	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend				Drill Holes	Offse				TENEDE I TOTAL			
	be Date Step Qty Ita Dooling Correct Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube			n	Drawing	Out o	f Calibration	7 - 1					
et e	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				Finish	Out o	f Sequence	79- 103					

Outside Dimensions

Wave/Twist in Tube

Required Date: 9/20/2013

Required Qty: 250.00

Start Date: 8/27/2013

Start Qty: 250.00

Tuesday, August 27, 2013 7:30:15 AM

Work Order II:

105940

Parent Item:

Comments:

D2230-3

Parent Item Name:

MOUNTING LUG

Ý.

IPP D00.05.18Added inspection level 8, and removed P/O for powder

coatEC

IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED

BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P		Purchased	No				Each	0.0000		250	1/1/2	Tuch.	16
LUG							2	I Steemmerstein			10	11/101	-
D2423		Manufactured	No				f	268.9220		17.97368	14 C 21	3/10	155
Lug Extrusion									-		are	2110	(2)
				Location		Loc Oty	Loc	c Code					
				MAT006		221.5			-				
				8795	3	221.5			<u> </u>	8_			
				Metec		47.422							
				9355	1	47.422							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

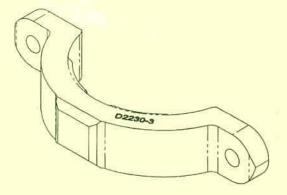
DQA:	Date:	, i	+ 2
	4 1		212

					uit-					- LE CHIC	QA Closed:	Date	
Work Orde	r:									T DEF	DEPARTMENT/PROCESS		
E-					Rework			Skid-tube	Crosstub	e		Water Jet	Engineering
Part N	0.				Scrap		1	Machining	Small Fa	b	Pro	d. Eng. Coor.	Quality
					Use-as-is		Therm	noforming	Finishin	g	Rec/Stor	re/Packaging	Other
NCR N	0.				Work Order Update			Large Fab	Composit	e		Supplier	
										4	- 112		
Root				Descri	ption of work order update	In	itial	Ac	ction	=D3	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Desc	cription	150	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling										9			
Operator						1 8							
Material						-				- 1			
Setup							a T	P 47		- 4			
Other						F 1				-	34		
Process						BIF 9					12	THE PARTY IN	
Supplier						1.03	ensen					GO TO I	Halling St.
Training													
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F-VI	Cracks				Broken/Damaged		nspecti	ion Incomplete		15	Part Incorre	ct	Weld
	Crushed	I/Crimped			Burrs		nstruct	ions Incomplete	/Unclear	-3	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs				Contamination	-		enance			Part Moved		
Great (Heat Tr	eat			Countersink		Mis abe	eled		10.0	Positioned V	Vrong	
Inspection Strip in Tube				Cut Too Short	-	Misread				Power toss/		Other	
Ripples in Bend			Drill Holes		Offset								
Torque Waves in Extrusion			Drawing	Out of Calibration									
Turning Sequence			Finish	Out of Sequence					de la				
Wave/Twist in Tube				Folio	Outside Dimensions				1. 黄椒。				

D2230-1

D2230-1 MOUNTING LUG

CX13/08/27 W10: 165940



D2230-3 MOUNTING LUG



G	STAND	TO PREVENT	ORKS TO CURRENT DESIGN TO SECTION A-A & B-B FILLET CHAFING OF RUBBER CUSHION ON	AJS	09.01.36			
F	REDESI	GN; R1.200 W	AS 1.100	CP	99,12,13			
E	RE-DES	IGN		BW	95.01.04			
D	RE-DES	IGN		BW	95.01.34			
C	RE-DES	IGN	and the second s	BW	94.03.30			
REV.			DESCRIPTION	BY	DATE			
DESIG	N	BW	DART AEROSPA	CEL	TD			
DRAW	N	AJS	HAWKESBURY, ONTARI	O. CANAL	DA			
CHECK	KED	51	DRAWING NO.		REV. G			
MFG. A	APPR.	Und.	D2230		SHEET FOF 3			
APPRO	OVED	(M)	TITLE		SCALE			
	mm	1	MOUNTINGLUG	OLINTING LUG				



D

C

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS
0) F0.015=0.005.
7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

8

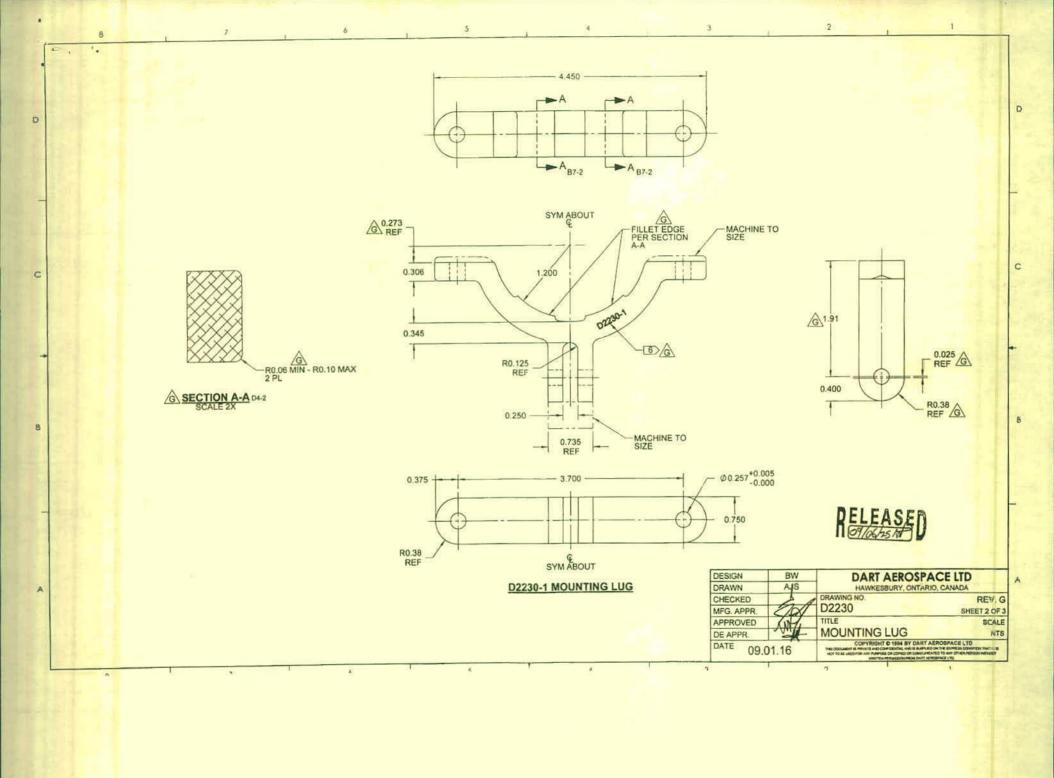
09.01.16

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	16:	# W 2
	CONTRACTOR OF		* 3

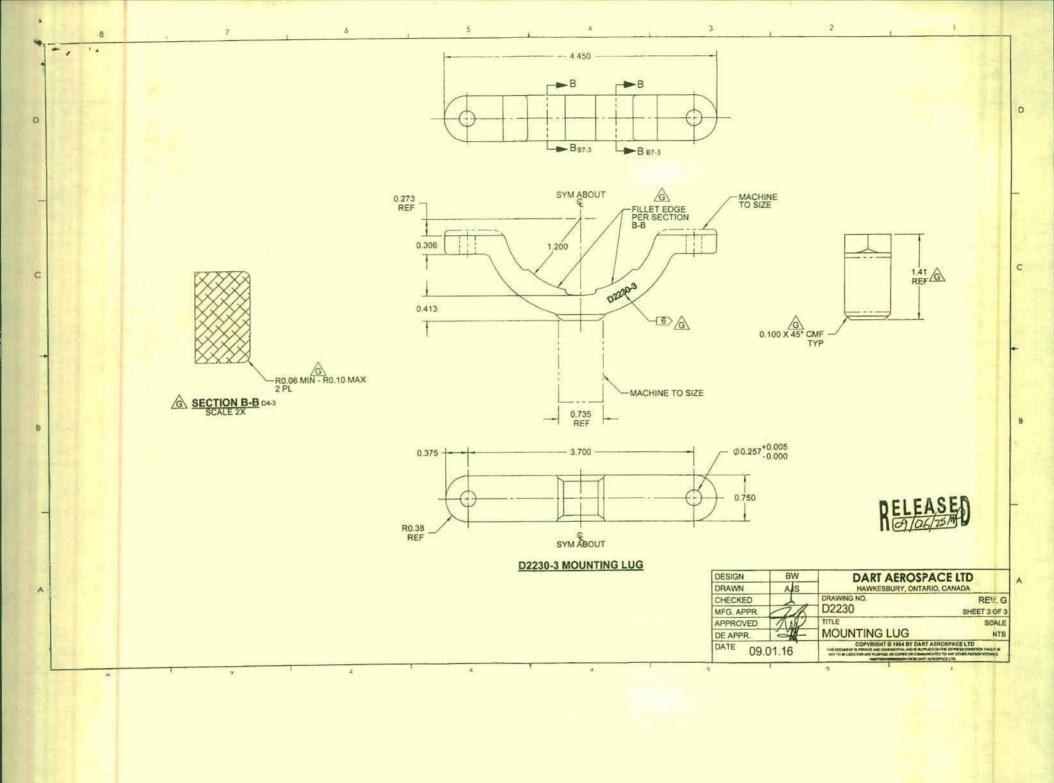
A.		19		HEATTH.	d as in		QA Closed: Date:					
Work Orde	r.					DISPOSITION			AGAINST DE	PARTMENT/	PROCESS	
Part N	lo					Rework Scrap Use-as-is Work Order Update		Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
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	_	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorrec	t	Weld
		Crushed/0	Crimped			Burrs		tions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
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2		Wave/Tw	ist in Tul	oe		Folio	Outside	e Dimensions				



NCR: Y	es / No				WORK ORDER N	ON-COM	NFORM/	ANCE / UF	PDATE	OA ST.	Date		
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Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector	
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	Crushed/Crimped				Burrs	() () () ()		ns Incomplete	Unclear	Part Lost/Mi	ssing	_Wr⊖ng Stock Pulle	d
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	Heat Tre		Tuba	-	Countersink Cut Too Short		Mislabeled	3	-	Positioned W		Other	
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Outside Dimensions

Wave/Twist in Tube



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NCR N	0				Work Order Update		Large Fab	Composite		Supplier	
Root Cause	Date	Step	Qty		ption of work order update	Initial Chief Eng		ction	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	oc/Data quip/Tooling perator faterial etup ther roccess upplier raining						CORV				
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	Cuffs			-	Countersink	\mathbf{H}	enance		Part Meved Positioned V		
2- 2-	Heat Treat Inspection Strip in Tube				Countersink Cut Too Short		Mislabeled Misread			/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish



A.T.G. INDUSTRIES INC. 731 INDUSTRIELLE STREET ROCKLAND, ON K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 906675

Date: 03-Oct-13

To

DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 Canada

Ship To

CHANTAL LAVOIE DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7

Canada

Ph: 613 632-9577

erms	Fax: 613 632-1053		613 632-9577	Fax: 613 632-1053
erms		Ship Via		
Quantity	Description			
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.			
2 ea	Part: D2230-3P MOUNTING LUG		Rev: G	
	Job: 14996	PO: PO21082	Line: 1	
2 ea	Part: D3235-1P MOUNTING LUG		Rev: A	
	Job: 14997	PO: PO21082	Line: 2	
2 ea	Part: D3910-3P X-TUBE LUG		Rev: B	
	Job: 14998	PO: PO21082	Line: 3	
	CERTIFIED SIGNATURE :			

